



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D5661-045
Job Sheet 201821



Part No: D5661-045

Job Qty: 4 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5661 Rev A / DSK182 Rev A IPP Rev. A 19.09.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs		11/1/19	0.17	1.00	Waterjet - Flow		JRB 11/13/19
120	QC 2	4 pcs		11/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S231323

Part: D5661-045

Job No: 201821

Serial No/Batch: S231323

Revision: A/A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/13/19

PRIORITY

130 QC 8	4 pcs	11/1/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 11/13/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	NOV 13 2019 40
				QC 8 - 52	9-86
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - Brake NC - B4B	4 pcs	11/1/19	0.25 0.67	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	NOV 13 2019
150 QC 5	4 pcs	11/1/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
155 Automated Welding - B4B	4 pcs	11/1/19	0.25 0.67	QC 5 - 61	
				QC 5 - 81	
160 Large Fab - Welded Assy-2-	4	11/1/19	0.00 2.00	Automated Welding - 1 - B4B	
				Large Fab - 1 - B4B	

B4B	pcs				Large Fab - 10 - B4B						
					Large Fab - 2 - B4B	MV Nov 14/19					
					Large Fab - 3 - B4B						
					Large Fab - 4 - B4B						
					Large Fab - 5 - B4B						
					Large Fab - 6 - B4B						
					Large Fab - 7 - B4B						
					Large Fab - 8 - B4B						
					Large Fab - 9 - B4B						
					Large Fab - 11 - B4B (Various)						
					Large Fab - 12 - B4B						
					170 QC 9	4 pcs	11/1/19	0.00	0.00	QC 9 - 10	
										QC 9 - 18	
QC 9 - 24											
QC 9 - 43											
QC 9 - 50	CE										
QC 9 - 9											
180 QC 5	4 pcs	11/1/19	0.00	0.00	QC 5 - 10						
					QC 5 - 12						
					QC 5 - 17						
					QC 5 - 18						
					QC 5 - 19						
					QC 5 - 22						
					QC 5 - 24						
					QC 5 - 3						
					QC 5 - 43						
					QC 5 - 49						
					QC 5 - 51						
					QC 5 - 58						
					QC 5 - 68						
					QC 5 - 9						
					QC 5 - 50	CE					
					QC 5 - 30						
					QC 5 - 40						
QC 5 - 61											
QC 5 - 81											
190 Spray Paint - 2 - B4B	4 pcs	11/1/19	0.00	0.33	Spray Paint - 1 - B4B						
					Spray Paint - 2 - B4B	RD 19-11-14					
					Spray Paint - 3 - B4B						
					Spray Paint - 4 - B4B						
200 QC 5	4 pcs	11/1/19	0.00	0.00	QC 5 - 10						
					QC 5 - 12						
					QC 5 - 17						
					QC 5 - 18						
					QC 5 - 19						
					QC 5 - 22						
					QC 5 - 24						
					QC 5 - 3						
					QC 5 - 43						
					QC 5 - 49						
					QC 5 - 51						
					QC 5 - 58						
					QC 5 - 68						
					QC 5 - 9						
					QC 5 - 50						
					QC 5 - 30						
					QC 5 - 40						
					QC 5 - 61						
						DAS 40 NOV 15 2019 9-59					
					Plex 10/11/19 1:36 PM Dart.lajeunesse.marie						

210 Packaging 3-1 - Stock - B4B	4	✓	11/1/19	0.00 0.00	QC 5 - 81	WP001		
pcs	Oscar	NOV 1 5 2019	Packaging 3 - 1 - B4B	Packaging 3 - 2 - B4B	Packaging 3 - 3 - B4B ✓	Packaging 3 - 4 - B4B		
Packaging 3 - 5 - B4B								
Packaging 3 - 6 - B4B								
Packaging 3 - 7 - B4B								
Packaging 3 - 8 - B4B								
Packaging 3 - 9 - B4B								
Packaging 3 - 10 - B4B								
Packaging 3 - 11 - B4B								
Packaging 3 - 12 - B4B								
Packaging 3 - 13 - B4B								
Packaging 3 - 14 - B4B								
Packaging 3 - 15 - B4B								
Packaging 3 - 16 - B4B								
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Packaging 3 - 28 - B4B								
Packaging 3 - 29 - B4B								
Packaging 3 - 30 - B4B								
Packaging 3 - 31 - B4B								
Packaging 3 - 32 - B4B								
Packaging 3 - 33 - B4B								
Packaging 3 - 34 - B4B								
Packaging 3 - 35 - B4B								
Packaging 3 - 36 - B4B								
220 QC 21 - SA			4	✓	11/1/19	0.00 0.00	QC 21 - SA - 21 ✓	WP001
pcs			QC 21 - SA - 70	21				
			QC 21 - SA - 53	53				
Part Op 110 - 1-Cut DSK182-5F as per DWG. DWG. Rev: <u>A</u> PROG. Rev: <u>A</u> 2-Deburr if necessary Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - FORM D5661-5 WEARPLATE AS PER DWG 150 - (QC5- Inspect part completeness to step on W/O) 155 - ***USE DT10493*** APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) BATCH: <u>M139025</u> 160 - ***MINIMUM 7 WELDS DISTRIBUTED ACROSS SHIM AND MINIMUM 1 WELD PER INDICATED COLUMN*** 1- WELD SHIMS AS PER DWG A/R Hardcoat S.S. Batch: <u>M136585</u> 2- TRANSFER DRILL 00.188 DRAIN HOLE FROM WEARPLATE THRU SHIM 170 - (QC9- Inspect visual per QSI004- Fusion Welds) 180 - (QC5- Inspect part completeness to step on W/O) 190 - 1- COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9 BATCH: <u>5227567</u> 2- OPEN UP DRAIN HOLE IF NECESSARY TO 0.188 AFTER APPLYING TEXTURED COATING AS PER DWG 3- INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER AFTER FINISH 200 - (QC5- Inspect part completeness to step on W/O) 210 - (Identify as per dwg & Stock Location: _____) 220 - (QC21- Final Inspection - Work Order Release)								

NOV 1 5 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	8,6080 sf (2.152 ea)	110-Waterjet - Flow - 1	S227400
D4682-13	Saddle Shim	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	S224876
D4682-9	Wearplate Shim	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	S227435
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S18GA	9	123	0
160-Large Fab - Welded Assy-2- B4B	D4682-13	4	0	0
	D4682-9	4	29	0
Part Specifications				
Specifications could not be found.				

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INSPECTION SHEET

DAS

40
9-89

Date:Revised by

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																													
Description Work Order Deviation		Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Other/Details:																																	
		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																															